

# Work Order ID 86187

**\*86187\***

Page 1

Item ID: D3789-7

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Clamp

Stop **\*NS2\***

Start Date: 22/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/22* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3789	Rev A

100	0.00
-----	------

**\*100\***

Bandsaw

Jeapn Bandsaw

Memo

Cut extrusion to .820"

*cut @ meter*

*CX 12/06/26*

110	0.00
-----	------

**\*110\***

HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA834

Dwg Rev:

Folio Rev:

Deburr

*P10:17295*

*CX 12/06/26 20*

*issue P 10 to meter*

*machine as per dwg D3789 REV - A*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86187

**\*86187\***

June-22-12 1:54:30 PM

Item ID: D3789-7

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Clamp

Stop **\*NS2\***

Start Date: 22/06/2012 Start Qty: 20.00 **\*20\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00 **\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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~~N5~~ *rec'd*  
**\*115\***

QC  
Quality Control

~~QC2-Inspect parts off machine FAI/FAIB~~

0.00

Memo

0.00

*rec'd + inspect for transit damage.  
attached c of c to WIO*

120  
**\*120\***

QC  
Quality Control

QC8-Inspect parts - second check

0.00

Memo

0.00

*8.7.14*

*12-07-11*

130  
**\*130\***

HandFinish  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*20 127-11*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Work Order ID 86187

June-22-12 1:54:30 PM

**\*86187\***

Page 3

Item ID: D3789-7

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Clamp

Stop **\*NS2\***

Start Date: 22/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC	Memo	0.00				20	0	12-7-11.	
Quality Control									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat	Memo	0.00				20X	0	12/07/12	M-F
Powder Coating	*****Mask bearing bore prior to powder coat***** START TIME: 8:00 OVENTEMPERATURE: 3200F FINISH TIME: 8:30								
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00				20x	0	12-10-12	
Quality Control									

W121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*86187\***

Page 4

June-22-12 1:54:30 PM

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Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Clamp

Stop **\*NS2\***

Start Date: 22/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <b>ST 462</b>	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

20x **SD**  
**12-7-13**

**12/7/18**

**MF**  
**12-07-16**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

June-22-12 1:54:34 PM

Work Order ID: 86187

\*86187\*

Parent Item: D3789-7

\*D3789-7\*

Parent Item Name: Clamp

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: A New Issue 08-12-10 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	462.0150	0.07	1.473684			

\*D2423\*

Lug Extrusion

\*\*

CL 12/06/24

Location

Loc Qty

Loc Code

MAT006

462.015

43722

161.5

68331

43.8506

81557

256.6644

1.48

D3789-7P

CL 12/7/10 (20)

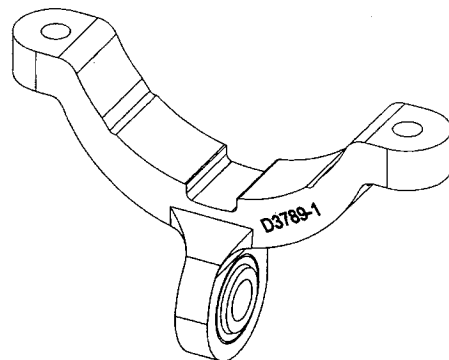
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

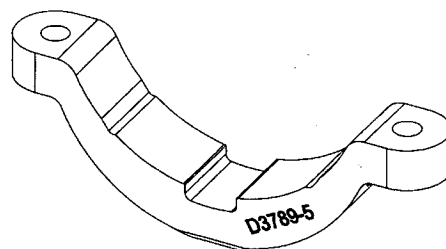
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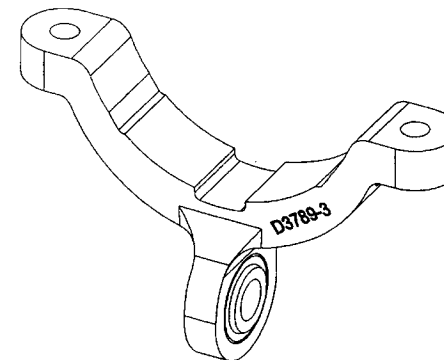
**NOTE:** Date & initial all entries



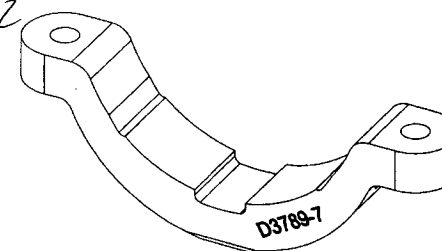
**D3789-1 CLAMP**



**D3789-5 CLAMP**



**D3789-3 CLAMP**



**D3789-7 CLAMP**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 86187 MJS





12/00/22

DEO ATTACHED

RELEASED  
08/12/22

**NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs  
D3789-3, 0.16 lbs  
D3789-5, 0.14 lbs  
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMETRICAL ABOUT  $\phi$

A		NEW ISSUE		HS	08.05.21
REV.		DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	HS				
CHECKED		DRAWING NO.		REV. /	
MFG. APPR.		D3789		SHEET 1 OF	
APPROVED		TITLE		SCALE	
DE APPR.		CLAMP		NTS	
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**Dart Aerospace Ltd**

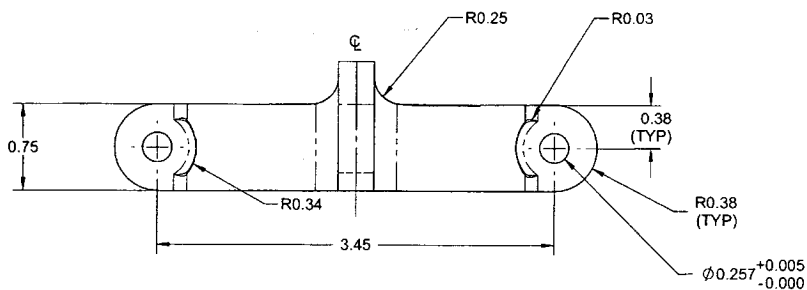
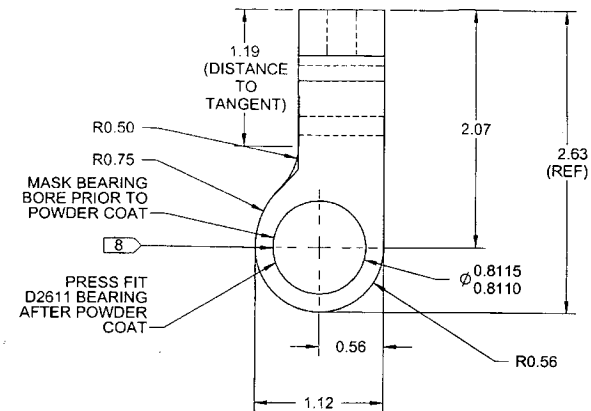
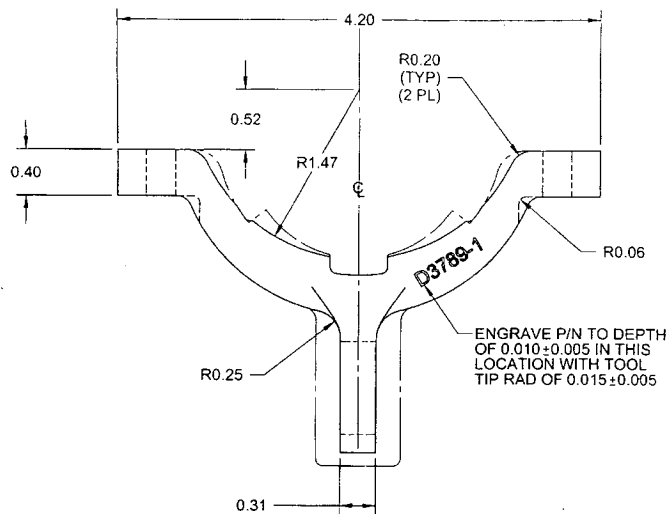
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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


**NOTE:** Date & initial all entries



**D3789-1 CLAMP**

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CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.		D3789	SHEET 2 OF 5
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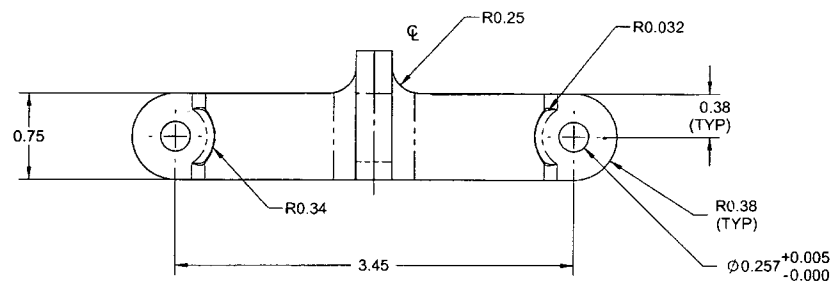
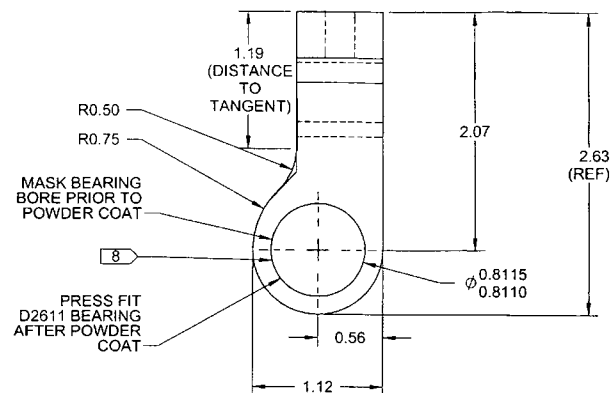
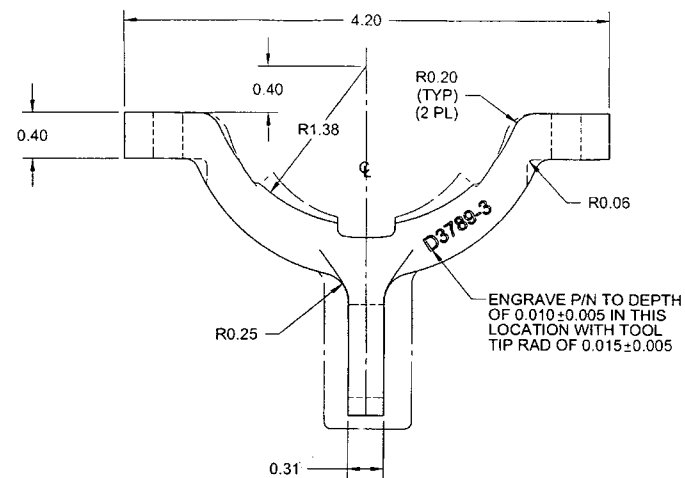
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**D3789-3 CLAMP**

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08/12/21

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MFG. APPR.	<i>[Signature]</i>	D3789	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

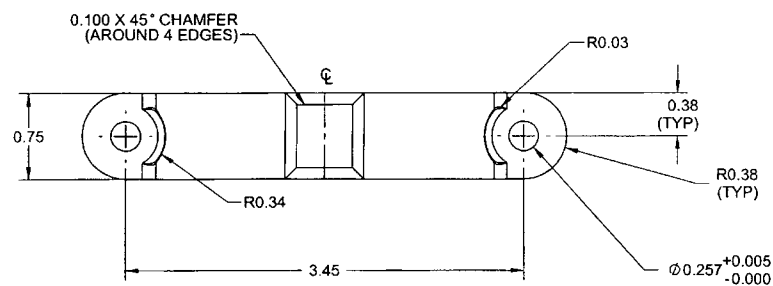
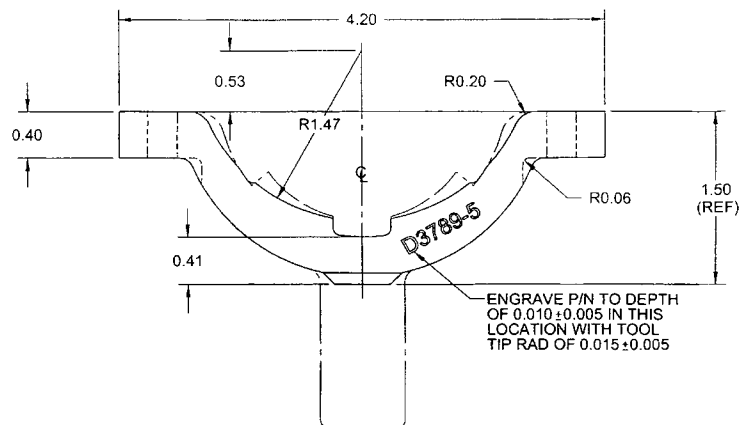
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**NOTE:** Date & initial all entries





**D3789-5 CLAMP**

26127

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08/12/21

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MFG. APPR.		TITLE	SHEET 4 OF 5
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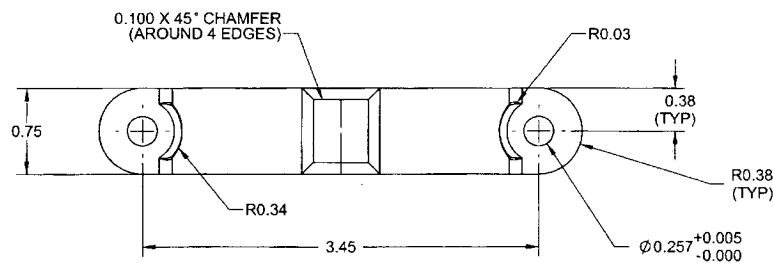
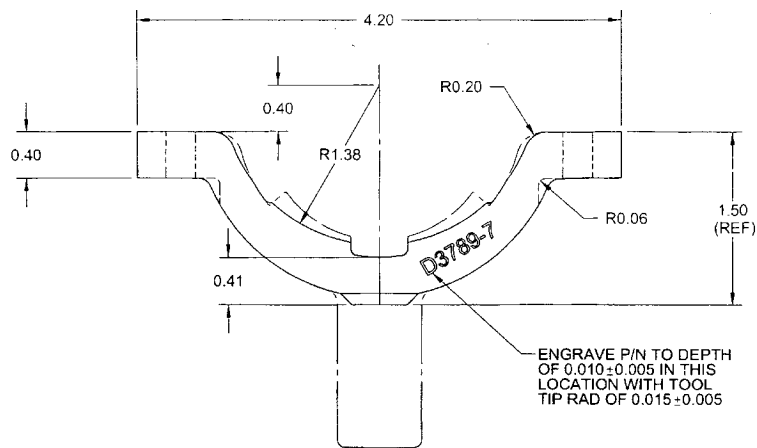
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MFG. APPR.		TITLE <b>CLAMP</b>	SHEET 5 OF 5
APPROVED			SCALE NTS
DE APPR.		DATE <b>08.05.21</b>	
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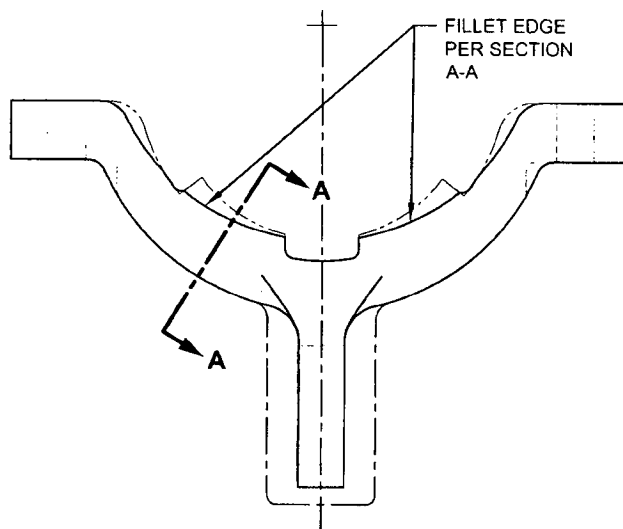
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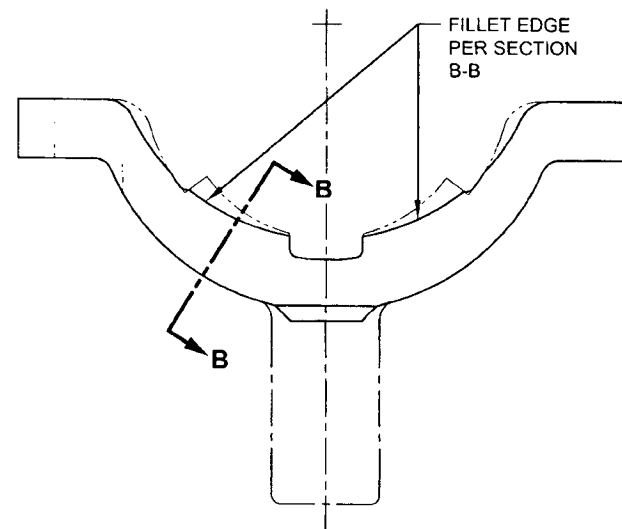
**NOTE:** Date & initial all entries

DRAWING NO. D3789	TITLE CLAMP	REV. A	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D3789-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>AJS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23	DATE 09/04/23		

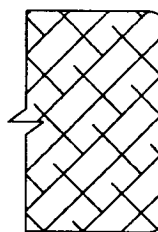
ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3789-1 CLAMP  
D3789-3 CLAMP



D3789-5 CLAMP  
D3789-7 CLAMP



R0.06 MIN - R0.10 MAX  
2PL

SECTION A-A  
SCALE 2X  
SECTION B-B  
SCALE 2X

**RELEASED**  
*09/05/04 [Signature]*

SEE PAR 122 FOR FURTHER DETAILS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 18572

**Date:**

Jun 29, 2012

**Page:**

1

<b>Sold to:</b>  <b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 17295	<b>Sold By:</b> Dewar, Eric
<b>Shipped By:</b> your truck	<b>Ship Date:</b> Jul 06, 2012

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3789-3 Clamp as per dwg. D3789 Rev.A B86188	Each	20	20	
D3789-7 Clamp as per dwg. D 3789 Rev.A B86187	Each	20	20	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0  
Tel. (613) 673-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	D3789-3	Clamp	17295
20	D3789-7	Clamp	17295

MATERIAL: supplied by DART B81557

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, July 9, 2012



